Work Orde April-11-13 2:2		9620		*996	520*	·					Page 1
	D3864-1			Accept	*N900	040	100)* s	etup Star	t *N	S1*
Revision ID: Item Name:	Bushing								Sto) *NI	CO*
	_	Q1 . Q1 . Q1 . Q	+0.4+						•	171	S2*
	4/11/13	Start Qty: 24.00	*24*			Cust Item ID:					
Required Date: Reference:	4/11/13	Req'd Qty: 24.00	*24*		Customer:						
Approvals:	Process I	Plan: MLJ	Date: 13-04-17	ZTooling:	Da	ate:	•	R	tun Star	171	R1*
• •			Date:		Da	ate:			Stop	` *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	R	evision Nbr									
D3864	R	ev A									
100		•		0.00					The state of the s		
100		Hardinge CNC LATHE S	SMALL	. .	ll.	2-04-1	8	24	Ø		
Hardinge		Memo		0.00	201						
Hardinge CNC Lath	e Small	1-TURN AS REV: <u>ル/4</u>	PER FOLIO FA794 & DV _DWG REV: A 2	VG D3864 ,FOLIO -DEBURR AS REQUIRI	ED						
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00					٠		
110				•	24		_,	24	D		
QC		Memo		0.00	St.	3-04-1	8				
Quality Control											
			٠.								>
120		QC8- Inspect parts - seco	ond check	0.00				2 (1	1		DAS
120		N .f		0.00	13-4-19			24	Ψ		_68 <mark>-89_</mark>
Quality Control		Memo		0.00					•		

NCR:	Yes	/ No				WORK ORDER NON-O		NFORM	MANCE / UPI	DATE		•			
											٠, .	QA Closed:	Da	te:	
Mork Orde	- ·					DISPOSITION				AGAINST I	DE	PARTMENT	PROCESS		
Work Orde Part N	•					Rework Scrap]	i e	Skid-tube Machining	Crosstube Small Fab		Pro	Water Jet d. Eng. Coor.		Engineering Quality
NCR I	•					Use-as-is Work Order Update		Therm	noforming Large Fab	Finishing Composite			e/Packaging Supplier		Other
Root					Descri	ption of work order update	I	nitial	Act	tion		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descr	ription		Dáte	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					-										
Onapproved				<u> </u>	l	F	AUL	T CATE	GORY			L	<u> </u>		1
Landi	ng G	Gear				General		0, (, ,							_
	<u> </u>	Bending Centre No	ot Concer	ntric to	o/s	Bend BOM/Route	F	Grain Hardwa	re			Ovalized Over/Under	tolerance	E	Pressure/Forced Temperature/Cure
		Cracks				Broken/Damaged] Inspecti	on Incomplete			Part Incorre	ct		Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/I	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	t			Countersink		Mislabe	eled			Positioned V	Vrong		7
		Inspection	n Strip in	Tube		Cut Too Short		Misread	t l			Power Loss/	Surge		Other
		Rinnles in	Rend			Drill Holes		Offset		•					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Ord April-11-13 2:2		620	-	*996	320*							Page 2
Item ID: Revision ID:	D3864-1	·		Accept	*N900	040	100)*	Setup	Start	*N:	S1*
Item Name: Start Date: Required Date Reference:	Bushing 4/11/13 : 4/11/13	Start Qty: 24.00 Req'd Qty: 24.00	-	4* 4*	Cust Item II Customer:) :				Stop	*N:	S2*
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Da	te:	_	1	Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center I	D	Operation Description Identify as per dwg & Sto	ck Location	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
120 Packaging Packaging		Memo		0.00			•	ÓU X			<u> </u>	3-4
*140 *1 4 0*		QC21- Final Inspection -	Work Order Relea	se 0.00					1	3/4	1/22	2 HA
QC		Memo		0.00								

Quality Control

& somo

DQA:	Date:
201.	

VCR:	Yes	1	No
VI.D.	163	,	INU

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Dat	e:
Work Ordei					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap	4 1	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0	·-·			Use-as-is Work Order Update	Thern	noforming Large Fab	Finishing Composite	Rec/Stoi	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Act	ion	Sign &		A SURVEY OF
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
	-				F	AULT CATE	GORY				
Landin	g Gear				General				-	-	
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route	Hardwa	ire	<u> </u>	Over/Under	tolerance	Temperature/Cure
L	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped	-		Burrs	}	ions Incomplete/U	Jnclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Trea	at			Countersink	Mislabe	eled		Positioned V		
	Inspectio	n Strip in	Tube		Cut Too Short	Misread	t		Power Loss/	Surge	Other
	Ripples in	n Bend		L	Drill Holes	Offset					
	Torque W	Vaves in E	Extrusion	n [Drawing	Out of 0	Calibration				· · · · · · · · · · · · · · · · · · ·
	Turning S	equence			Finish	Out of 9	Sequence				
	Wave/Tw	ist in Tul	oe .		Folio	Outside	Dimensions				

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April-11-13 2:23:43 PM

Work Order ID:

99620

Parent Item:

D3864-1

Parent Item Name:

Bushing

Start Date: 4/11/13

Required Date: 4/11/13

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP Rev:A

New Issue JLM 08-12-06 Verified By:EC

Comments		10000 02111 00 11	- 00										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000 303 Round Bar 1.00		Purchased	No			100	f	109.8903	0.101 3.3	2.551579 SO	2 ff 1	3-04-1	8
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT028		109.8903158							
				12086	6	1.4							
				12107	0	6.63031579							
				12128	32	0.9				<u> </u>			
				12172	8	3.034							
				12238	6	14.926							
				12329		5			<u> </u>				
				112471	17	78			3.3	50			

										,		
NCR:	res / No				WORK ORDER NON-C	CON	FORM	MANCE / UPDATE		QA Closed:	Date:	
			• 4		DISPOSITION			AGAINST D				The second se
Work Orde	er:				, Dawe at [, I		Shid Auba Casastuba			Water Jet	Engineering
Part N	No	-,			Rework Scrap Use-as-is		ı	Skid-tube Crosstube Machining Small Fab noforming Finishing			d. Eng. Coor.	Quality Other
NCR N	No				Work Order Update			Large Fab Composite			Supplier	
Root				Descri	ption of work order update	lr	nitial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Description	\perp	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling				Ì						ļ	•	
Operator		•							1			
Material												
Setup			1								+	
Other												
Process												
Supplier												
Training		Į										
Unapproved			<u> </u>		·	<u> </u>						
					F.	AUL1	CATE	GORY				
Landi	ng Gear				General			_				-
	Bending				Bend		Grain	<u> </u>	$\overline{}$	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	O/S	BOM/Route	\vdash	Hardwa		-	Over/Under		Temperature/Cure
	Cracks				Broken/Damaged		-	ion Incomplete	-	Part Incorred	<u> </u>	Weld
	Crushed	/Crimped			Burrs	\vdash		ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			l	Contamination		Mainte	enance	-	Part Moved		

Mislabeled

Out of Calibration
Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio DOA:

Positioned Wrong

Power Loss/Surge

Other

Date:

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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DART AEROSPACE LTD	Work Order:	99620
Description: Bushing	Part Number:	D3864-1
Inspection Dwg: D3864 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	T -1	Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø0.625	+/-0.010	:625			5102	Mic
Ø0.472	+/-0.010	,472	V.		5102	Mic
Ø0.386	+0.006/-0.001	.472			5L08	Vein
0.572	+/-0.010	.572				Vect
0.118	+/-0.010	-116	1			
1.190	+/-0.010	1.190			1	
Ø0.787	+0.010/-0.001	. 7865	V		5402	Mic
R0.005 to R0.010	N/A	.008			V	1,0
					P	
					-gj	
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						ATT TO THE TOTAL PROPERTY OF THE TOTAL PROPE
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fleasured by:		Audited by:	SA.		Preliminary A	pproval:
Date: 13	-04-18		3-4-			Date:

Rev	Date	Change	Revised by	Approved
A	09.05.20	New Issue .	KJ , N	
В	10.12.21	Tolerances revised	KJ KJ	+ 1/2
			7	

